

NCR-19-7751



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4680-041**Job Sheet 179486**

Part No: D4680-041

Job Qty: 1 ea

Part Name: Skidtube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/11/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 13.04.16 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB2 DD VERF:JLM IPP REV:C 13.09.10 PB3 DD VERF:JLM IPP REV:D 13.11.14 AS PER DWG REV.B DD VERF:JLM IPP REV:C 14.11.24 AS PER DWG REV.C DD VERF:JLM IPP REV:D 15.06.10 AS PER DWG REV.D DD VERF:JLM IPP REV:E 16.03.23 AS PER DWG REV.E DD VERF:JLM

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/11/18	0.00	0.00	Start Up Skid tubes-2		BE
120	Skid tubes	1 pcs		7/11/18	0.00	4.86	Skid tubes-2		DD DAS
140	QC	1 pcs		7/11/18	0.00	0.00	QC5		38
150	HandFinish	1 pcs		7/11/18	0.00	0.73	HandFinish1		SA 18-07-18
160	QC	1 pcs		7/11/18	0.00	0.00	QC7-4		MGA
170	Skid tubes	1 pcs		7/11/18	0.00	4.86	Skid tubes-2		DAS BE
180	QC	1 pcs		7/11/18	0.00	0.00	QC5		38
210	HandFinish	1 pcs		7/11/18	0.00	0.73	HandFinish2		9-89 3.4
220	Powdercoat	1 pcs		7/11/18	0.00	0.17	Powdercoat1		Ag JUL 20 2018
230	QC	1 pcs		7/11/18	0.00	0.00	QC3		AL 18-7-23
260	HandFinish	1 pcs		7/11/18	0.00	0.73	HandFinish4		AL DAS-273
270	QC	1 pcs		7/11/18	0.00	0.00	QC5		38
300	Packaging	1 pcs		7/11/18	0.00	0.00	Packaging3-2		DAS 9-89
310	QC21-SA	1 Ea		7/11/18	0.00	0.00	QC21		21 JUL 27 2018

Part Op 120 - 1-Cut Aft end as per dwg D4680 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 open aft cap 0.187". 4-Locate Descriptions: DT10149 & Drill Ground wire hole on top of Tube. 5-Locate DT10149 with 0.187" cleco in aft cap, then Pilot Drill all X-Bolt holes using 0.187" drill. 6-Open ground wire hole .297" at 95.75" (1 at fwd end & 2 at aft end at 20.81" ref.) 8- 3 most fwd x-bolt holes must be laid out manually, open to #30. 9-Open Aft & Fwd Cap holes using .208" drill. 10- Open X-Bolt holes to .750" (10 places) 11- Drill Rivet Holes as per Dwg D4680 using DT10065 ***DO NOT DRILL RIVET HOLES ON SECTION G-G (TWO PLACES) Open G-G to .750 12-Deburr holes.

170 - 1- Bond web as per Dwg D4680 & QSI 015 2- Seal all faying surfaces using proseal and rivet Doubler as per Dwg D4680. A/R Proseal Batch: 13848 exp date: 2018/11 ***LET IT CURE FOR 7HRS*** START TIME: FINISH TIME: 3- Rivet doublers as per dwg Shave rivet as required, remove

Proseal spill over. 4- Ream holes section C-C as per dwg, deburr 8 places 5- Swage x-bolt spacers as per Dwg D4680 and section I C-C 8 places. 6- Swage x-bolt spacer as per dwg D4680 section G-G 7- Trim/Grind flush per QSI 002

210 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - START TIME: Primer BS084461 Paint 138886

260 - 1- Install Ground Wire inserts as per Dwg D4680. 2-Inspect for Foreign objects 3- Install Fwd & Aft caps as per Dwg D4680 and Detail "A" & "B". Fastener must be install wet as per note (9). Seal all faying surfaces note (8) A/R 241 Sika Flex Batch: Exp Date: 4- Wing Walk as per Dwg D4680 and QSI 005 4.4

Batch:

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D4680-041-BENT	Extrusion Bent	1 Ea (1 ea)	90-Start up Operation	5088795
D5520-1	Doubler	2 Ea (2 ea)	120-Skidtubes	5082764
CR3212-5-05	Rivet	68 pcs (68 ea)	170-Skidtubes	5061120
D4681-041	Web Assembly	1 Ea (1 ea)	170-Skidtubes	5091124
AELS-1032-130	Rivnut	3 Ea (3 ea)	260-HandFinish	5007234
AN3C4A	Bolt	3 Ea (3 ea)	260-HandFinish	5060642
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	5057153
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	5051642
D2965	Cap	1 Ea (1 ea)	260-HandFinish	5040482
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	5176364
D4686-1	Spacer	8 Ea (8 ea)	260-HandFinish	5063873
D5304-1	Crossbolt Spacer	2 Ea (2 ea)	260-HandFinish	5014553
MS20601-AD4W3	Rivet	32 Ea (32 ea)	260-HandFinish	5092087
NAS1149C0332R	Washer	5 Ea (5 ea)	260-HandFinish	5056492
D4753-1	Doubler	16 Ea (16 ea)	300-Packaging	5088133

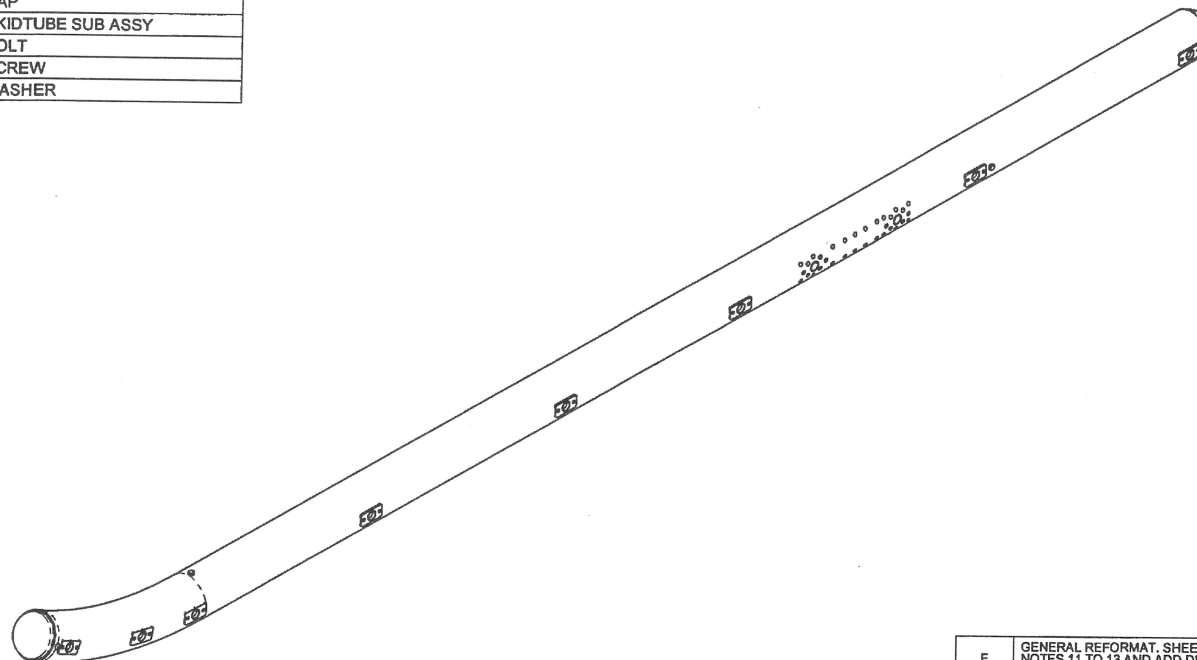
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4680-041-BENT	1	1	0
120-Skidtubes	D5520-1	2	10	0
170-Skidtubes	CR3212-5-05	68	746	0
	D4681-041	1	2	0
260-HandFinish	AELS-1032-130	3	0	0
	AN3C4A	3	1,807	0
	AN3C5A	2	1,655	0
	AN526C1032R10	2	178	0
	D2965	1	80	0
	D2965-3	1	30	0
	D4686-1	8	82	0
	D5304-1	2	27	0
	MS20601-AD4W3	32	1,163	0
	NAS1149C0332R	5	5,349	0
300-Packaging	D4753-1	16	136	0

Part Specifications				
Specifications could not be found.				

Plex 6/19/18 3:09 PM dart.white.jesse

DART
 AEROSPACE
 Container No: S091476
 Part: D4680-041
 Job No: 179486
 Serial No/Batch: S0914
 Revision: F
 Inspector:
 Exp Date:
 Instructions:

ITEM	QTY	P/N	DESCRIPTION
	X	D4680-041	SKIDTUBE
1	1	D2965	CAP
2	1	D2965-3	CAP
3	1	D4680-043	SKIDTUBE SUB ASSY
4	2	AN3C5A	BOLT
5	2	AN526C1032R10	SCREW
6	2	NAS1149C0332R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER QSI 005 SECTION 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4680-041" AND B/N PER QSI 044 METHOD 6.4 ON INNER RADIUS OF SKIDTUBE BEFORE INSTALLING D2965 CAP
- 7) WEIGHT: 19.3 lbs
- 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 CLASS B-2 SEALANT
- 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 CLASS B-2 SEALANT

RELEASED
2017-08-11
ECN 17-547

F	GENERAL REFORMAT. SHEET 3: ADD ITEMS 8 & 11 ADD NOTES 11 TO 13 AND ADD DETAIL H. SHEET 5: Ø0.188 WAS 0.750. WEIGHT UPDATE. ADD PROSEAL 1422	AJS	17.03.30
E	GROUND HANDLING CROSSBOLT SPACERS NOW SWAGED, WAS WELDED. REMOVED D3492-055 PLUG ASSEMBLIES	AP	15.11.02
D	MOVED AFT GROUNDING FASTENER HOLE AFT 0.25 DUE TO INTERFERENCE. ADDED NOTE 9 (SHT 1), GROUNDING STRAP WASHERS NOW STAINLESS	AP	15.03.04
C	NAS1149F0332P WAS AN960-10L, AN526C1032R10 WAS AN526C1032-10, FWD GROUNDING STRAP FASTENER MOVED AFT (C2-3), Ø0.750 WAS Ø0.758 (B4-3).	AP	14.07.29
B	FWD CAP WAS D2985 NOW D2985-3. VARIOUS DIMENSIONAL CHANGES. D3492-055 PLUG ASSY WAS D3492-051, SWAGING DIMENSION NOW 0.650 WAS 0.661 (D6-2), ADDED DETAIL H (C2-3), MATERIAL D2962-150 WAS D2962-131 (A7-3), GROUND HANDLING THRU HOLES NOW WELDED, ADDED SECTION G-G (D3-2)	AP	13.09.10
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. F
MFG. APPR.	DP	D4680	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
DATE	17.03.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DORPED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

AN526C1032R10
SCREW
2 PL

D2965-3
CAP

DETAIL A
SCALE 4X

D2965
CAP

AN3C5A BOLT
NAS1149C0332R WASHER
2 PL

DETAIL B
SCALE 4X

D4680-043
SKIDTUBE

15.0

59.8

20.6

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EUGENE, OR

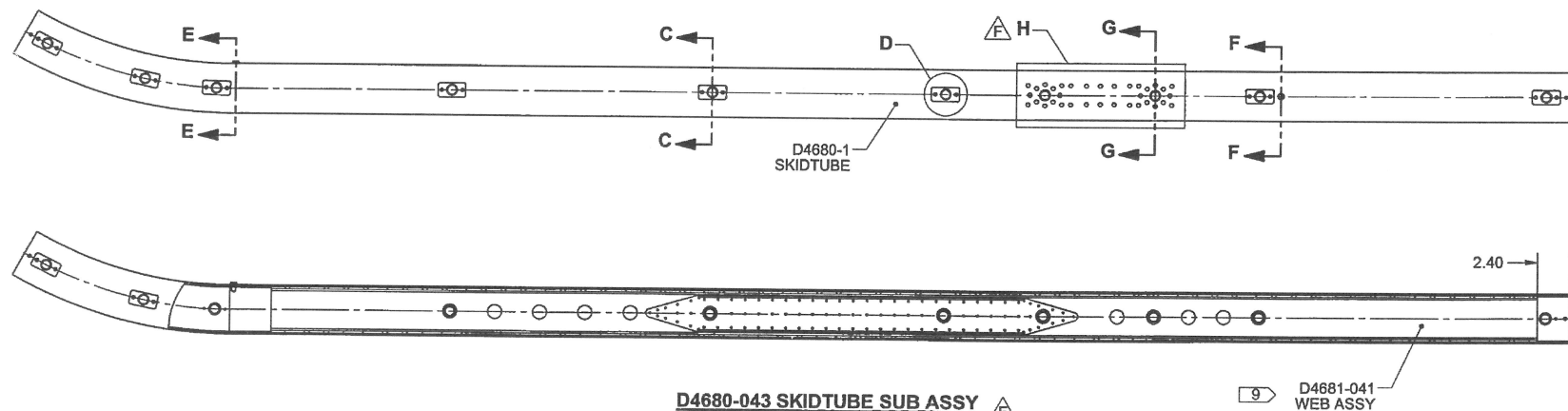
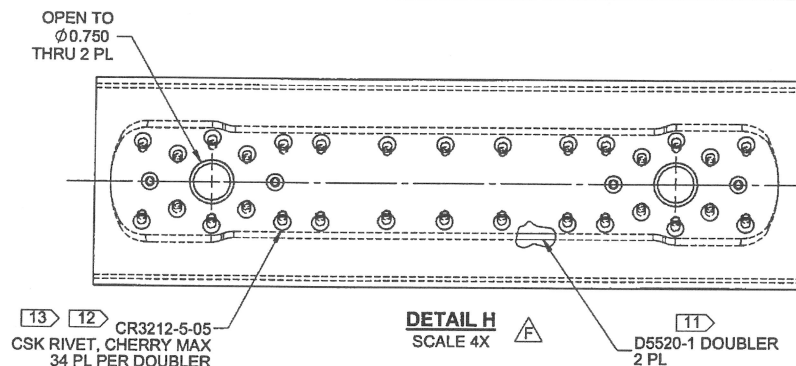
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DRAWN AJS
CHECKED ML
MFG. APPR. DP
APPROVED WM
DE APPR. DS
DATE 17.03.30

DRAWING NO.
D4680
TITLE
SKIDTUBE
REV. F
SHEET 2 OF 5
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2017-08-11
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ITEM	QTY -043	P/N	DESCRIPTION
	X	D4680-043	SKIDTUBE SUB ASSY
1	1	D4680-1	SKIDTUBE
2	1	D4681-041	WEB ASSY
3	8	D4686-1	SPACER
4	16	D4753-1	DOUBLER
5	2	D5304-1	CROSSBOLT SPACER
6	2	D5520-1	DOUBLER
7	3	AN3C4A	BOLT
8	32	MS20601AD4W3	RIVET, BLIND, CSK
9	3	NAS1149C0332R	WASHER
10	3	AELS-1032-130	INSERT
11	68	CR3212-5-05	CSK RIVET, CHERRY MAX



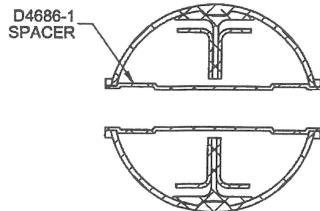
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: APPLY CHEMICAL CONVERSION COATING PER DART QSI 005 4.1 PRIOR TO INSTALLING D4681-041 WEB. POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 18.6 lbs
- 8) SEAL ALL MATING SURFACES USING PROSEAL 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSERT D4681-041 WEB INTO D4680-1 SKIDTUBE IN LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015
- 10) INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS
- 11) LOCATE THE D5520-1 DOUBLER USING THE Ø0.188 PILOT HOLES ON THE SKIDTUBE AND DOUBLER
- 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309
- 13) COUNTERSINK THE SKIDTUBE Ø0.286 X 100° (34 PL) AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS

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2017-08-11

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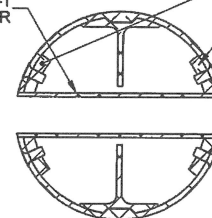
DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. F
MFG. APPR.	DP	D4680	SHEET 3 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
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SECTION C-C
SCALE 4X
8 PL

- INSTALL D4686-1 SPACER AS FOLLOWS (8 PL)
AFTER INSTALLING D4753-1 DOUBLERS PER DETAIL D
1. INSERT D4686-1 SPACER
 2. SWAGE TO $\phi 0.650 +0.010/-0.000 \times 1.0$
DEEP PER QSI 002
 3. TRIM/GRIND FLUSH PER QSI 002

D5304-1
CROSSBOLT SPACER

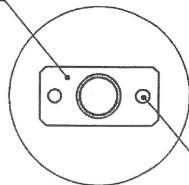


SECTION G-G 
SCALE 4X
2 PL

D5520-1 DOUBLER
REF

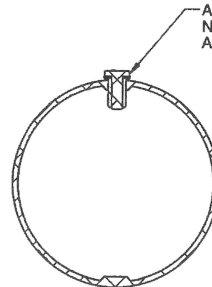
- INSTALL D5304-1 SPACER AS FOLLOWS (2 PL)
1. INSERT D5304-1 SPACER
 2. SWAGE TO $\phi 0.585 +0.005/-0.000 \times 1.0$
DEEP PER QSI 002
 3. OPEN THRU HOLE TO $\phi 0.625$

8
D4753-1
DOUBLER



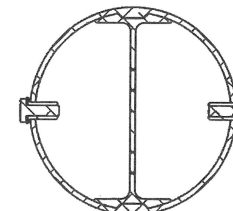
DETAIL D
16 PL (BOTH SIDES)
SCALE 4X

MS20601AD4W3
RIVET, BLIND, CSK
2 PL



SECTION E-E
SCALE 4X

AN3C4A BOLT
NAS1149C0332R WASHER
AELS-1032-130 INSERT



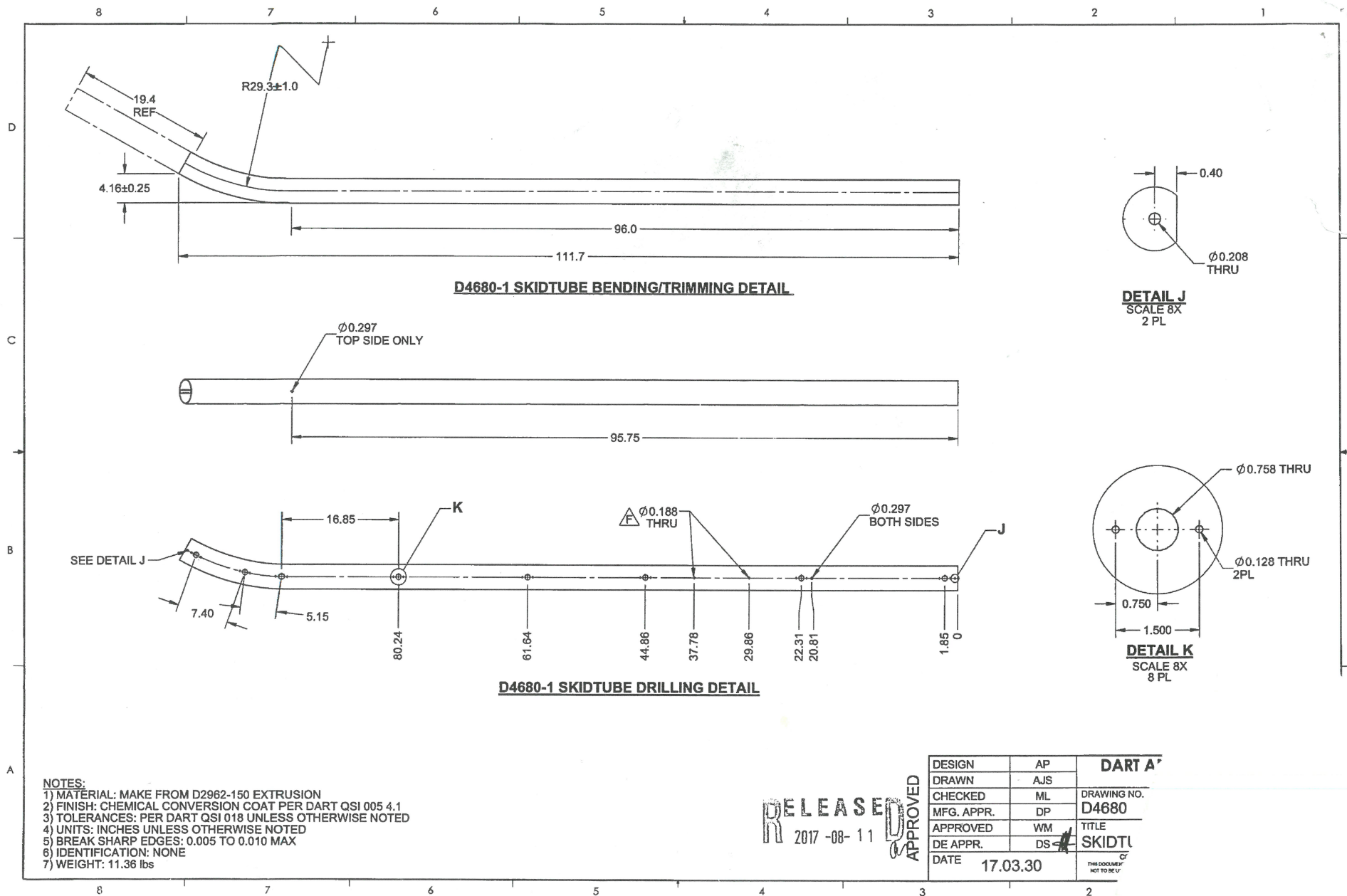
SECTION F-F
SCALE 4X

AN3C4A BOLT
NAS1149C0332R WASHER
AELS-1032-130 INSERT
2 PL

RELEASED
2017-08-11

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DESIGN	AP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. F
MFG. APPR.	DP	D4680	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
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NOTES:

- 1) MATERIAL: MAKE FROM D2962-150 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 11.36 lbs

RELEASED
2017-08-11
APPROVED

DESIGN	AP	DART A
DRAWN	AJS	
CHECKED	ML	DRAWING NO.
MFG. APPR.	DP	D4680
APPROVED	WM	TITLE
DE APPR.	DS	SKIDT
DATE	17.03.30	THIS DOCUMENT NOT TO BE USED

Linda Lacelle

From: Chris Provencal
Sent: Monday, July 23, 2018 10:52 AM
To: Linda Lacelle; Marc Bellavance
Cc: Andrew Sheldon; Jesse White; Jason Leroux
Subject: RE: bahh humbug

Linda,

It is acceptable to ship the D4680-041 skidtubes with prime/paint per QSI 005. ICA-D117-762 Rev. 4. permits the skidtube to be painted. Attach this email to the work order and have someone deviate the work order as "Acceptable per DE #03 attached email".

Chris

From: Linda Lacelle
Sent: Monday, July 23, 2018 7:18 AM
To: Chris Provencal <cprovencal@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>
Cc: Andrew Sheldon <asheldon@dartaero.com>; Jesse White <jwhite@dartaero.com>; Jason Leroux <jleroux@dartaero.com>
Subject: FW: bahh humbug
Importance: High

Not sure who is on vacation, but these tubes need to ship tomorrow, Tuesday, July 24, can we proceed, as we spray painted them instead of powder coat...we were all so sure that the 145's were spray painted!!

Thx
L

From: Linda Lacelle
Sent: Friday, July 20, 2018 5:07 PM
To: Linda Lacelle <llacelle@dartaero.com>
Subject: Fwd: bahh humbug

Sent from my iPhone

Begin forwarded message:

From: Andrew Sheldon <asheldon@dartaero.com>
Date: July 20, 2018 at 4:55:39 PM GMT-4
To: Linda Lacelle <llacelle@dartaero.com>, Jesse White <jwhite@dartaero.com>
Subject: Re: bahh humbug

everything says powder coat, either way they are painted, would just need eng sign off

From: Linda Lacelle
Sent: Friday, July 20, 2018 4:54:31 PM
To: Andrew Sheldon; Jesse White
Subject: Re: bahh humbug

Nothing on the drwg???? We always painted these! Wtf

Sent from my iPhone

On Jul 20, 2018, at 4:53 PM, Andrew Sheldon <asheldon@dartaero.com> wrote:

nothing about it on the drawing or wo

From: Linda Lacelle
Sent: Friday, July 20, 2018 4:52:38 PM
To: Andrew Sheldon
Subject: Re: bahh humbug

Uh yeah, why???

Sent from my iPhone

On Jul 20, 2018, at 4:51 PM, Andrew Sheldon <asheldon@dartaero.com> wrote:

are the D4680-041's supposed to be painted?

Entered: 2R Date: 18/07/23 Nov 19/19



NCR No. 19-7751

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>179486</u> Part No. <u>D4680-041 Rev F</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☒ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☒ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																															
Date : <u>19-05-11</u>		Sequence #: <u>220</u>		QTY Affected : <u>1</u>		MRB (QSI042) <u>NO</u>																													
Description Work Order Deviation				Disposition		Completed By <u>NO</u>																													
Skid tubes primed and painted instead. DWG calls for powder coat				Use as is. ICA-D117-762 Rev. 4 permits prime and paint. Acceptable per DE#03 attached e-mail.		Lead hand / Supervisor <u>PD 19-05-11</u>																													
Root Cause				QC / QA Coordinator <u>PD 19-05-11</u>																															
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☒ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☒ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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		Other/Details:																																	